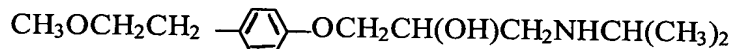


## CLAIMS

We claim:

1. A process for obtaining an aryloxypropanolamine of the chemical name 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol of the formula

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comprising:

- 10 A) combining 4-(2-methoxyethyl)phenol with epichlorhydrin;  
B) reacting said combination of 4-(2-methoxyethyl)phenol and epichlorhydrin in an alkaline aqueous medium;  
C) extracting and washing the organic phase reaction product of Step B with water at pH  $7.5 \pm 0.5$ ; and  
15 D) obtaining a crude reaction product comprising 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane;  
E) combining said 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane with isopropanolamine;  
F) reacting said combination of 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane and isopropanolamine in an aqueous medium at a  
20 temperature about  $30^\circ\text{C}$ , to obtain 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol.

2. The process of claim 1, wherein:

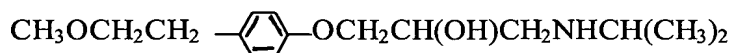
- A) said 4-(2-methoxyethyl)phenol and said epichlorhydrin are combined in a molar ratio of about 1 : 1.31.

25 3. The process of claim 2, wherein:

- B) said reacting 4-(2-methoxyethyl)phenol and epichlorhydrin is at  $42.5 \pm 2.5^\circ\text{C}$ ; and  
D) said crude reaction product is composed of about 97 to 99% of 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane.

4. The process of claim 3, wherein:
- E) said 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane and isopropanolamine are combined in a molar ratio of about 1 : 5.25.
5. The process of claim 4, further comprising:
- 5 G) extracting said 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol from said aqueous reaction medium with a polar solvent at a temperature of not more than about 25° C; and
- H) removing said solvent by distillation under reduced pressure.
6. The process of claim 5, further comprising:
- 10 I) combining said 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol with succinic acid in a molar ratio of approximately 1 : 2 in a solution of pH about 7.2, and
- J) isolating from said solution the succinate form of said 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol.
- 15 7. The process of claim 5, further comprising:
- I) combining said 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol with tartaric acid in a molar ratio of approximately 1 : 2 in a solution of pH about 6.2; and
- J) isolating from said solution the tartarate form of said 1-[4-(2-methoxyethyl)-
- 20 phenoxy]-3-[(1-methylethyl)amino]-2-propanol.

8. A product of the chemical name 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol of the formula



5 made by a process comprising:

- A) combining 4-(2-methoxyethyl)phenol with epichlorhydrin;
- B) reacting said combination of 4-(2-methoxyethyl)phenol and epichlorhydrin in an alkaline aqueous medium;
- C) extracting and washing the organic phase reaction product of Step B with  
10 water at pH  $7.5 \pm 0.5$ ; and
- D) obtaining a crude reaction product comprising 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane;
- E) combining said 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane with isopropanolamine;
- 15 F) reacting said combination of 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane and isopropanolamine in an aqueous medium at a temperature about  $30^\circ \text{C}$ , to obtain 1-[4-(2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol.

9. The product of claim 8, wherein:

- 20 A) said 4-(2-methoxyethyl)phenol and said epichlorhydrin are combined in a molar ratio of about 1 : 1.31.

10. The product of claim 9, wherein:

- B) said reacting 4-(2-methoxyethyl)phenol and epichlorhydrin is at  $42.5 \pm 2.5^\circ \text{C}$ ; and
- 25 D) said crude reaction product is composed of about 97 to 99% of 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane.

11. The product of claim 10, wherein:

- E) said 3-[4-(2-methoxyethyl)phenoxy]-1,2-epoxypropane and isopropanolamine are combined in a molar ratio of about 1 : 5.25.

12. The process of claim 11, further comprising:

G) extracting said 1-[4-)-2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol from said aqueous reaction medium with a polar solvent at a temperature of not more than about 25° C; and

5 H) removing said solvent by distillation under reduced pressure.

13. The process of claim 12, further comprising:

I) combining said 1-[4-)-2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol with succinic acid in a molar ratio of approximately 1 : 2 in a solution of pH about 7.2, and

10 J) isolating from said solution the succinate form of said 1-[4-)-2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol.

14. The process of claim 12, further comprising:

I) combining said 1-[4-)-2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol with tartaric acid in a molar ratio of approximately 1 : 2 in a solution of pH about 6.2; and

15 J) isolating from said solution the tartarate form of said 1-[4-)-2-methoxyethyl)-phenoxy]-3-[(1-methylethyl)amino]-2-propanol.

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